

**Work Order ID 94391**

December-12-12 9:53:04 AM

**\*94391\***

Page 1

Item ID: D3039-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***Revision ID:   

Item Name: Centre Drill

Stop

**\*NS2\***

Start Date: 12/12/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 27/12/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12-12-12 Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D3039	Rev A	0.00							
-------	-------	------	--	--	--	--	--	--	--

110

**\*110\***

Small Fab

Memo  
CUT CENTER DRILL IN AFT AS PER DWG  
\*\*\*ONE CENTER DRILL MAKES TWO\*\*\*

20 φ FF 12-12-20

120

**\*120\***

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00 DAS 15 12-12-20 DAS 16 12-12-20

20

130

**\*130\***

Packaging

Packaging

Identify as per dwg & Stock Location: ST024 0.00

Memo

20 12/12/2012

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: Date:

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General							
				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled				

Work Order ID 94391

December-12-12 9:53:04 AM

\*94391\*

Page 2

Item ID: D3039-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Centre Drill

Stop

\*NS2\*

Start Date: 12/12/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 27/12/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

140

\*140\*

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

13/1/10 JJ

Memo

0.00

MF 12-12-27

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other								
Part No. _____															
NCR No. _____															
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector						
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
														<input type="checkbox"/> Other	

# Picklist Print

December-12-12 9:53:08 AM

Page 1

Work Order ID: 94391

\*94391\*

Parent Item: D3039-3

\*D3039-3\*

Parent Item Name: Centre Drill

Start Date: 12/12/2012

Required Date: 27/12/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.12.12 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3039-1		Manufactured	No				Each	0.0000		20		12/12/12	1/19

*\*D3039-1\**  
Centre Drill

*B 94390      \*\**

NCR: Yes / No

DQA: Date:

## WORK ORDER NON-CONFORMANCE / UPDATE

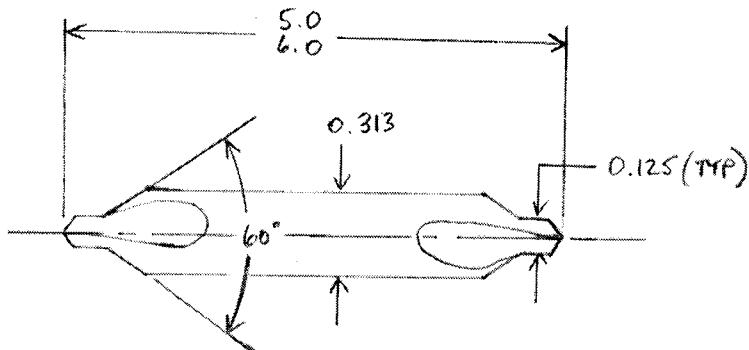
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

1 COPY  
100

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1
DATE	01.06.25	TITLE	SCALE NTS
		CENTRE DRILL	
A	01.06.25	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING



D3039-1 CENTRE DRILL (2 x D3039-3 CENTRE DRILL)

DESCRIPTION: #4 CENTRE DRILL PLAIN TYPE

POSSIBLE SUPPLIERS: ACKLANDS

MAIN INDUSTRIAL

KBC (PART # 1-047-450)

CUT IN HALF TO CREATE QTY (2) D3039-3 CENTRE DRILL FOR STOCK

ALL DIMENSIONS ARE IN INCHES

NO. 9439.1 MUL  
12-12-12  
WORK ORDER  
WITHDRAWN  
Build To Drawing  
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RELEASED  
01.06.25